

Date: Friday, 9/7/2007 10:14:17 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	END PLATE
Job Number	34454	Part Number	D30671
Estimate Number	10547	Drawing Number	D3067 REV A
P.O. Number	N/A	Project Number	N/A
This Issue	9/7/2007	Drawing Revision	A
Prsht Rev.	NC	Material	N/A
First Issue	N/A	Due Date	9/14/2007
Previous Run	34312	Qty:	100
Written By		Um:	Each
Checked & Approved By	<u>John.09.07</u>		
Comment	Est:03.01.21 Remove step 6 (Deburr) KJ Est Rev:B Now on Water jet 06-06-16 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M5052H32S063	5052-H32 .063 Sheet	
		Comment: Qty.: 0.0656 sf(s)/Unit Total : 6.5625 sf(s) 5052-H32 .063 Sheet Material: 5052-H32 (QQ-A-250/8) M5052H32S.063) or 6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063)	Batch: <u>110421</u> 103783 SAD 07/09/09
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3067 Dwg Rev: <u>A</u> Prog Rev: <u>A</u>	
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SAD 07/09/09 100
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	ER 07/09/11 4 100 Countes
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Bend as per Dwg D3067	SB 07/10/08 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: D3067-1 PAR #: N/A Fault Category: Prod Fab Ass ^{MSD + Small} NCR Yes No DQA: D Date: 07/10/12
 QA: N/C Closed: ~~S~~ Date: 07.10.12

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/10 2.0		Scrap 10 part, wrong material 2024 instead of 5052 R.C. Human error	S OSKAR	Scrap destroy replace	SAH 07/09/10	S 07/09/10	/	/

NOTE: Date & initial all entries

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Drawing Name: END PLATE

Job Number: 34454

Part Number: D30671

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO NEXT STEP

6 07/10/09 (X100) cover

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WIP4

11 07-10-12 (100)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 07/10/12 (100)

Job Completion



11 07/10/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34454
Description: End Plate	Part Number:	D3067-1
Inspection Dwg: D3067 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SAD	Audited by:	EP	Prototype Approval:	N/A
Date:	07/09/09	Date:	07/09/09	Date:	N/A

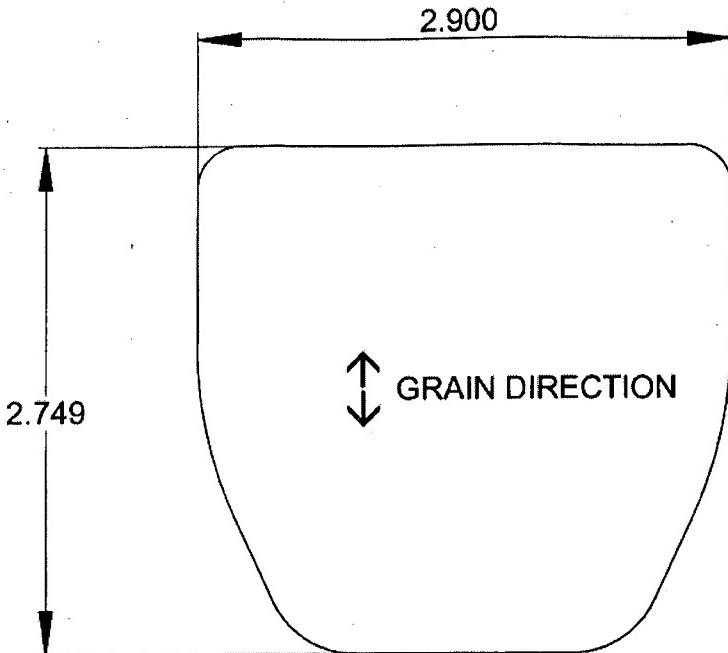
Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	TT



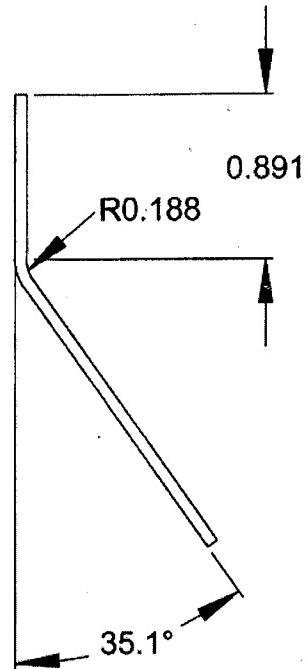
COPY ISSUED
TO

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3067	SHEET 1 OF 1
DATE	02.09.11	TITLE	SCALE 1:1
A	02.09.11	END PLATE NEW ISSUE	

RELEASED
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34454

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